

UNITED STATES PATENT AND TRADEMARK OFFICE  
DOCUMENT CLASSIFICATION BARCODE SHEET

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CATEGORY:

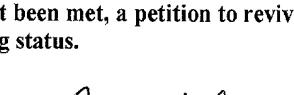
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ADDRESS  
CONTACT IF FOUND:

FORM PTO-1390 (REV 12-29-99)		U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE		ATTORNEY'S DOCKET NUMBER
<b>TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371</b>				41145
INTERNATIONAL APPLICATION NO. PCT/EP98/04832		INTERNATIONAL FILING DATE August 3, 1998		US APPLICATION NO (If known, see 37 CFR 1.5) <b>09/743710</b>
TITLE OF INVENTION METHOD FOR PRODUCING A SHAPED FOAM BODY, ESPECIALLY A FOAM PADDING ELEMENT FOR A VEHICLE SEAT				
APPLICANT(S) FOR DO/EO/US KONSTANTINOS POULAKIS; AXEL SCHULTE				
Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:				
<ol style="list-style-type: none"> <li>1. <input checked="" type="checkbox"/> This is a <b>FIRST</b> submission of items concerning a filing under 35 U.S.C. 371.</li> <li>2. <input type="checkbox"/> This is a <b>SECOND</b> or <b>SUBSEQUENT</b> submission of items concerning a filing under 35 U.S.C. 371.</li> <li>3. <input type="checkbox"/> This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).</li> <li>4. <input checked="" type="checkbox"/> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.</li> <li>5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371(c)(2))           <ol style="list-style-type: none"> <li>a. <input checked="" type="checkbox"/> is transmitted herewith (required only if not transmitted by the International Bureau).</li> <li>b. <input type="checkbox"/> has been transmitted by the International Bureau.</li> <li>c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US).</li> </ol> </li> <li>6. <input checked="" type="checkbox"/> A translation of the International Application into English (35 U.S.C. 371(c)(2)).</li> <li>7. <input checked="" type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))           <ol style="list-style-type: none"> <li>a. <input type="checkbox"/> are transmitted herewith (required only if not transmitted by the International Bureau).</li> <li>b. <input type="checkbox"/> have been transmitted by the International Bureau.</li> <li>c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired.</li> <li>d. <input checked="" type="checkbox"/> have not been made and will not be made.</li> </ol> </li> <li>8. <input type="checkbox"/> A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).</li> <li>9. <input checked="" type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).</li> <li>10. <input checked="" type="checkbox"/> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).</li> </ol>				
Items 11. to 16. below concern document(s) or information included:				
<ol style="list-style-type: none"> <li>11. <input checked="" type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98.</li> <li>12. <input checked="" type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.</li> <li>13. <input checked="" type="checkbox"/> A <b>FIRST</b> preliminary amendment.</li> <li><input type="checkbox"/> A <b>SECOND</b> or <b>SUBSEQUENT</b> preliminary amendment.</li> <li>14. <input type="checkbox"/> A substitute specification.</li> <li>15. <input type="checkbox"/> A change of power of attorney and/or address letter.</li> <li>16. <input checked="" type="checkbox"/> Other items or information: Translation of Preliminary Examination Report</li> </ol>				

16 JAN 2001

U.S. APPLICATION NO. (if known, see 37 CFR 1.5)		INTERNATIONAL APPLICATION NO PCT/EP98/04832		ATTORNEY'S DOCKET NUMBER 41145																					
CALCULATIONS PTO USE ONLY																									
<p>17. <input checked="" type="checkbox"/> The following fees are submitted:</p> <p><b>BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5) ) :</b></p> <p>Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO ..... <b>\$1,000.00</b></p> <p>International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO ..... <b>\$860.00</b></p> <p>International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO ..... <b>\$710.00</b></p> <p>International preliminary examination fee paid to USPTO (37 CFR 1.482) but all claims did not satisfy provisions of PCT Article 33(1)-(4) ..... <b>\$690.00</b></p> <p>International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(1)-(4) ..... <b>\$100.00</b></p>																									
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<p>c. <input checked="" type="checkbox"/> The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. <b>18-2220</b>. A duplicate copy of this sheet is enclosed.</p>																									
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<p>SEND ALL CORRESPONDENCE TO</p>																									
<p>Roylance, Abrams, Berdo &amp; Goodman, L.L.P. 1300 19th Street, N.W., Suite 600 Washington, D.C. 20036 (202) 659-9076</p>																									
<p> SIGNATURE Mark S. Bicks</p>																									
<p>NAME _____ 28,770 _____ REGISTRATION NUMBER _____</p>																									

U974371		U.S. APPLICATION NO (if known, see 37 CFR 1.5) <b>U974371</b> INTERNATIONAL APPLICATION NO PCT/EP98/04832	ATTORNEY'S DOCKET NUMBER 41145
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<p>1300 19th Street, N.W., Suite 600</p>			
<p>Washington, D.C. 20036</p>			
<p>(202) 659-9076</p>			
<p><i>Mark S. Bicks</i></p>			
<p>SIGNATURE</p>			
<p>Mark S. Bicks</p>			
<p>NAME</p>			
<p>28,770</p>			
<p>REGISTRATION NUMBER</p>			

## IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of

JC07 Rec'd PCT/PTO

16 JAN 2001

KONSTANTINOS POULAKIS ET AL. : PATENT  
Serial No.: NEW : Group Art Unit:  
Filed: Herewith : Examiner:  
For: METHOD FOR PRODUCING A SHAPED :  
FOAM BODY, ESPECIALLY A FOAM :  
PADDING ELEMENT FOR A VEHICLE :  
SEAT :

**PRELIMINARY AMENDMENT**

Commissioner for Patents  
Washington, D.C. 20231

Sir:

Preliminary to examination and calculation of the filing fee, please amend the above-identified application as follows:

Claim 4, line 1, change "Claims 1 to 3" to -- claim 1 --.

Claim 5, line 1, change "one of the Claims 1 to 4" to -- claim 1 --.

Claim 6, line 1, change "one of the Claims 1 to 5" to -- claim 1 --.

Claim 8, line 1, change "one of the Claims 1 to 7" to -- claim 1 --.

**REMARKS**

The above changes eliminate multiple dependency in the claims.

Respectfully submitted,

  
\_\_\_\_\_  
Mark S. Bicks  
Reg. No. 28,770

Roylance, Abrams, Berdo & Goodman, L.L.P.  
1300 19th Street, N.W.  
Washington, D.C. 20036  
(202) 659-9076  
Dated: Jan 13, 2001

Method for Producing a Shaped Foam Body, Especially  
a Foam Padding Element for a Vehicle Seat

The invention relates to a method for producing a foam body part, especially a foam padding element for a vehicle seat, which is provided with at least one adhesive closing part with adhering elements, wherein the adhesive closing part is arranged in a foaming mold producing the foam body part in such a manner that the adhering elements are protected against the penetration of foam by a foam-inhibiting covering which is arranged on the side of the adhesive closing part opposite the adhering elements with a predetermined border width overlapping the surface area of the adhering elements and is brought into releasable contact at least with parts of the foaming mold by means of a magnetic holding device, and the covering is provided with ferromagnetic component parts and at least one permanent magnet is provided on the foaming mold.

One method of this type is already known from the document WO-A-86 03164. One drawback with the known method is that the adhering elements of the adhesive closing part are not securely protected by means of the foam-inhibiting covering against a penetration of foam material. In order to guarantee the capacity of the adhesive closing parts to function, however, it is essential during the foaming process

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that adherence of the adhesive elements to each other by penetrating foam material be avoided.

Starting from this state of the art the invention proposes a method which facilitates the production of shaped foam bodies with adhesive closing parts foamed into the foam in an especially secure manner, whereby particularly the danger that foam material penetrating into the area of adhering elements leading to an adherence of the same is avoided.

With one method of the aforementioned type this problem is solved according to the invention in that the covering is provided with a ferromagnetic coating and that permanent magnets are used on the foaming mold in such a layered arrangement that they cooperate with the borders of the covering overlapping the surface area incorporating the adhering elements.

In an advantageous manner then the borders surrounding the area of the adhering elements are held in these border areas by effective magnetic forces in tight, sealing contact on the foaming mold, so that the sealing effect is guaranteed directly on those border areas endangered by penetration of foam material.

With one method known from the document US-A-5 654 070 for the foaming of adhesive closing parts on foam body parts, the arrangement of permanent magnets on the foaming mold along the side borders of the adhesive closing parts is already known in and of itself. With this method however adhesive closing parts are used without any sort of ferromagnetic component parts. Instead, with this method special, flexible plastic strips are provided as side sealing strips, which contain a magnetically attractive material in powder form. On the basis of the required precisely adapted application

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of these special sealing strips the execution of this method is costly and not cost-effective.

Preferably with the method of the invention the adhering elements are held during the foaming process in a recess worked in the shaping wall of the foaming mold, over the borders of which the covering overlaps with a predetermined border width sealing off the foam, and the recess is brought into contact with the border areas by means of the holding device.

The covering can be provided with a ferromagnetic coating of polyurethane, as is commercially available under the name SU-9182 from Firma Stahl and contains mixed-in Fe particles of granular size  $< 10\mu$  as ferromagnetic material.

As part of the magnetic holding device associated with the foaming mold the permanent magnets can be for example in the form of a series of magnetic rods or magnetic strips, which surround the recess formed in the wall of the foaming mold, in which are held the adhering elements of the adhesive closing part to be inserted in the foam.

Another object is an adhesive closing part which can be foamed into a foam body part, which has the features found in Claim 8.

Hereinafter the invention is to be described in greater detail relative to the drawing. In the drawing are shown :

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Fig. 1 a diagrammatically simplified perspective view of a foam padding element with adhesive closing part in the foam, seen in perspective view from the end;

Fig. 2 a view similar to that of Fig. 1 of a foam padding element with an adhesive closing part inserted in a recess in the foam;

Fig. 3 a partial section indicated in enlarged scale of an adhesive closing part inserted in a foaming mold;

Fig. 3A a greatly enlarged cutout of the area A of fig. 3;

Fig. 4 a perspective of a cutout of a foaming mold with inserted adhesive closing part;

Fig. 5 a diagrammatically simplified perspective view of a mold part which can be inserted into a foaming mold to form a blowhole or channel in the foam, and

Figs. 6 and 7 perspective views of the mold part of fig. 5 with adhesive closing part partially or completely engaged thereon.

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In the example of Fig. 2, adhesive closing part 3 is embedded in the foam in a recess 7 of foam padding element 1, so that the adhering elements 5 are arranged not flush with the surface.

Figs. 3 and 4 clearly show the foaming-in of adhesive closing part 3 in an arrangement running flush to the surface of foam padding element 1. In this case a foaming mold is used of which the shaping wall 9 has a recess 11 in the area of the adhesive closing part 3, which is adapted to the surface area of adhering elements 5 of adhesive closing part 3, so that with engagement of the same on wall 9 of the foaming mold, adhering elements 5 are received in recess 11. As shown in detail in Fig. 3A, adhering elements 5 are connected by means of an adhesive layer 13 forming a tight adherence with a covering element 15 laid out as a thin lamina on adhesive layer 13. This consists of a material which will enter into good binding with the foam material, for example a fleece or a felt. Covering element 15 extends out with its outer border areas over the surface area of adhering elements 5 and recess 11 constructed in wall 9 of the foaming mold, whereby the overlapping border width of covering element 15 is selected to be such that the border areas overlap the permanent magnets, which are represented in Figs. 3 and 3A as magnetic strips 17. Covering element 15 is provided with a ferromagnetic coating, for example a polyurethane coating with added Fe particles, whereupon ferromagnetic properties are ceded to covering element 15, so that the border areas adhere detachably to magnetic strips 17. This contact of the border areas of covering element 15, around the area of the adhering elements 5 held in the recess 11 of wall 9, forms a foam seal, which during the foaming process prohibits any penetration of the foam material into adhering elements 5.

The tight connection of adhering elements 5 with covering element 15, in deviation from the diagrammatic representation of Fig. 3A, can also occur directly through a polyurethane coating containing ferromagnetic substances, which can be for example the polyurethane SU-9182 of Firma Stahl. Alternatively, an additional adhesive layer 13 can be provided on the ferromagnetic

coating, for example a layer of a moisture-crosslinking polyurethane, for example Tivomelt 9617-11 of Firma Tivoli. As another possibility the construction of covering element 15 in the form of an adhesive base layer directly supporting adhering elements 5 can be considered, for example an adhesive base layer which contains synthetic resin or polyurethane together with ferromagnetic substances.

Fig. 4 shows the use of a plurality of magnetic rods 21 instead of the magnetic strips 17 shown in Figs. 3 and 3A. Magnetic rods 21 in Fig. 4 are arranged in a ring around recess 11 in wall 9 of the foaming mold in such a manner that the edges of the ferromagnetic covering element 15 are held to wall 9 in sealed contact.

Figs. 5 to 7 show in detail the process of the so-called blowhole or channel formation in the foam, whereby adhesive closing part 3 is set into recess 7 of the relevant foam padding part 1. For this purpose a mold part 23 is used which can be anchored to wall 9 of the foaming mold, having the recess 11 worked into its surface, in which can be received and protected the adhering elements 5 of the relevant adhesive closing part 3. On the narrow ends of recess 11 are found magnetic strips 17 for the contact of the narrow side border areas of ferromagnetic covering element 15. As shown in Figs. 6 and 7, its longitudinal side border areas are fitted around the rounded edges 25 of mold part 23, in order to come into foam-sealing contact with side magnetic strips 17.

Patent Claims

1. Method for producing a foam body part, especially a foam padding element (1) provided for a vehicle seat, which is provided with at least one adhesive closing part (3) with adhering elements (5), and the adhesive closing part (3) is arranged in a foaming mold (9) producing the foam body part in such a manner that the adhering elements (5) are protected against penetration of foam by a foam-inhibiting covering (15), which is arranged on the side of the adhesive closing part (3) opposite the adhering elements (5) arranged with a predetermined border width overlapping the surface area of the adhering elements (5) and is brought into detachable contact at least with parts of the foaming mold (9) by means of a magnetic holding device (17; 21), and the covering (15) is provided with a ferromagnetic coating and at least one permanent magnet (17; 21) is provided on the foaming mold (9), characterized in that the covering (15) is provided with a ferromagnetic coating and that permanent magnets (17; 21) are used on the foaming mold (9) in such a layered arrangement that they cooperate with the borders of the covering (15) overlapping the surface area of the adhering elements (5).
2. Method as in Claim 1, characterized in that polyurethane SU-9182 (Firma Stahl) is used as ferromagnetic coating with the addition of Fe particles.

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3. Method as in Claim 2, characterized in that the covering element (15) is connected by adhesive layer (13) with the adhesive closing part (3).
4. Method as in Claims 1 to 3, characterized in that a synthetic resin or polyurethane layer as well as a layer containing ferromagnetic substances is used as covering element (15) forming an adhesive base of the adhesive closing part.
5. Method as in one of the Claims 1 to 4, characterized in that a piece of felt or fleece laid on in a thin lamina is used as covering element (15) on the adhesive closing part.
6. Method as in one of the Claims 1 to 5, characterized in that the adhering elements (5) are held in a recess (11) of the foaming mold (9) and that the covering (15) is arranged with the predetermined border width overlapping the recess (11).
7. Method as in Claim 6, characterized in that for the formation of foam body parts with adhesive closing parts (3) arranged recessed therein a blowhole or channel formation is carried out with mold parts (23) having the recess (11) which as an entirely can be inserted in the foaming mold (9), on which are arranged permanent magnets (17) forming that part of the holding device, so that the borders of the covering element (15) overlapping the recess (11) are held thereon during the foaming process to inhibit foaming.

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8. According to the method as in one of the Claims 1 to 7, /an/ adhesive closing part (3) which can be inserted in a shaped foam body with a covering (15) overlapping the surface area of its adhering elements (5) with a predetermined border width, forms the part of a holding device for the releasable contact on parts of a foaming mold (9) serving for the production of the foam body parts and formed of a fleece or a felt laminated onto the adhesive closing part (3) and is provided with a ferromagnetic coating.

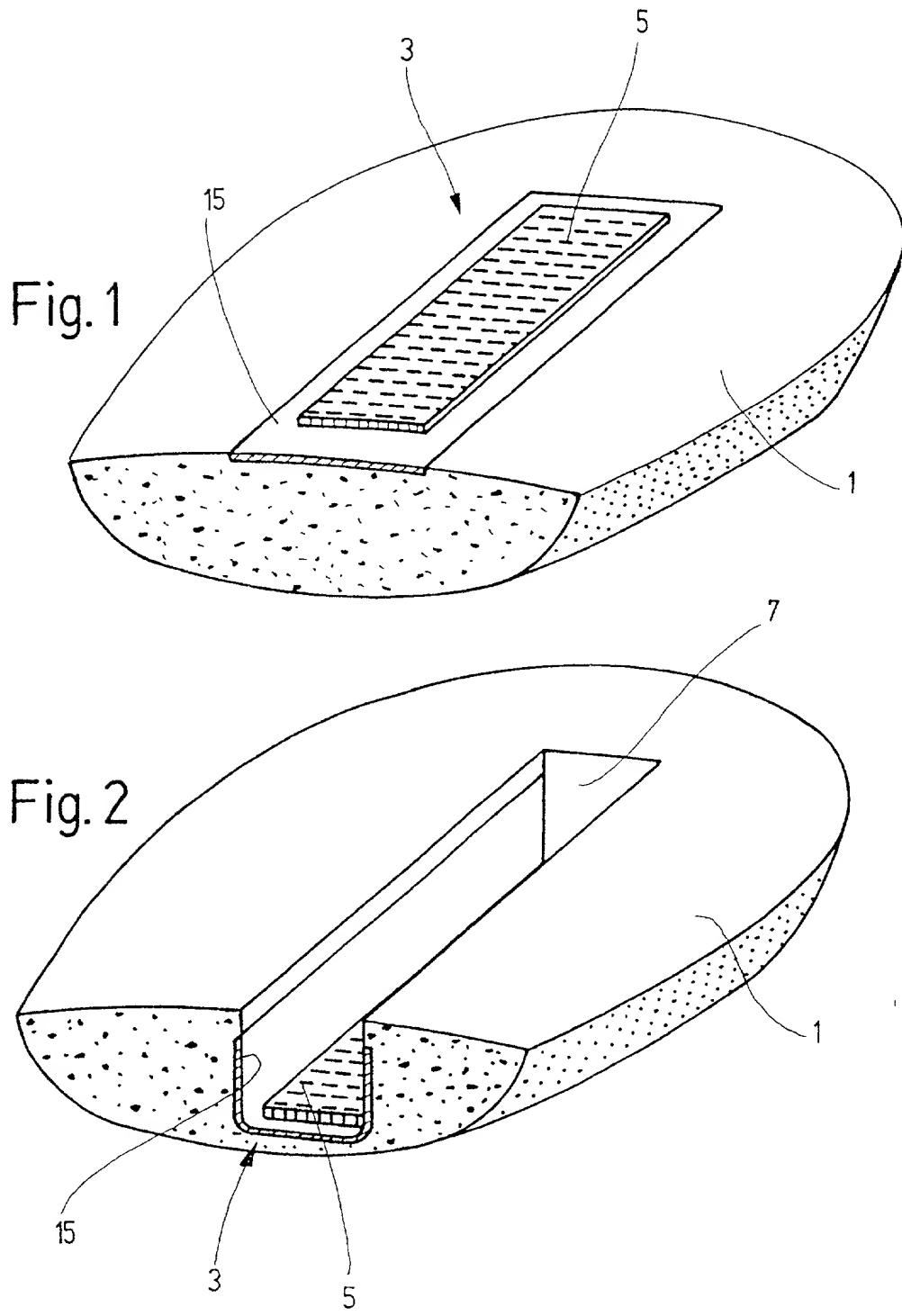
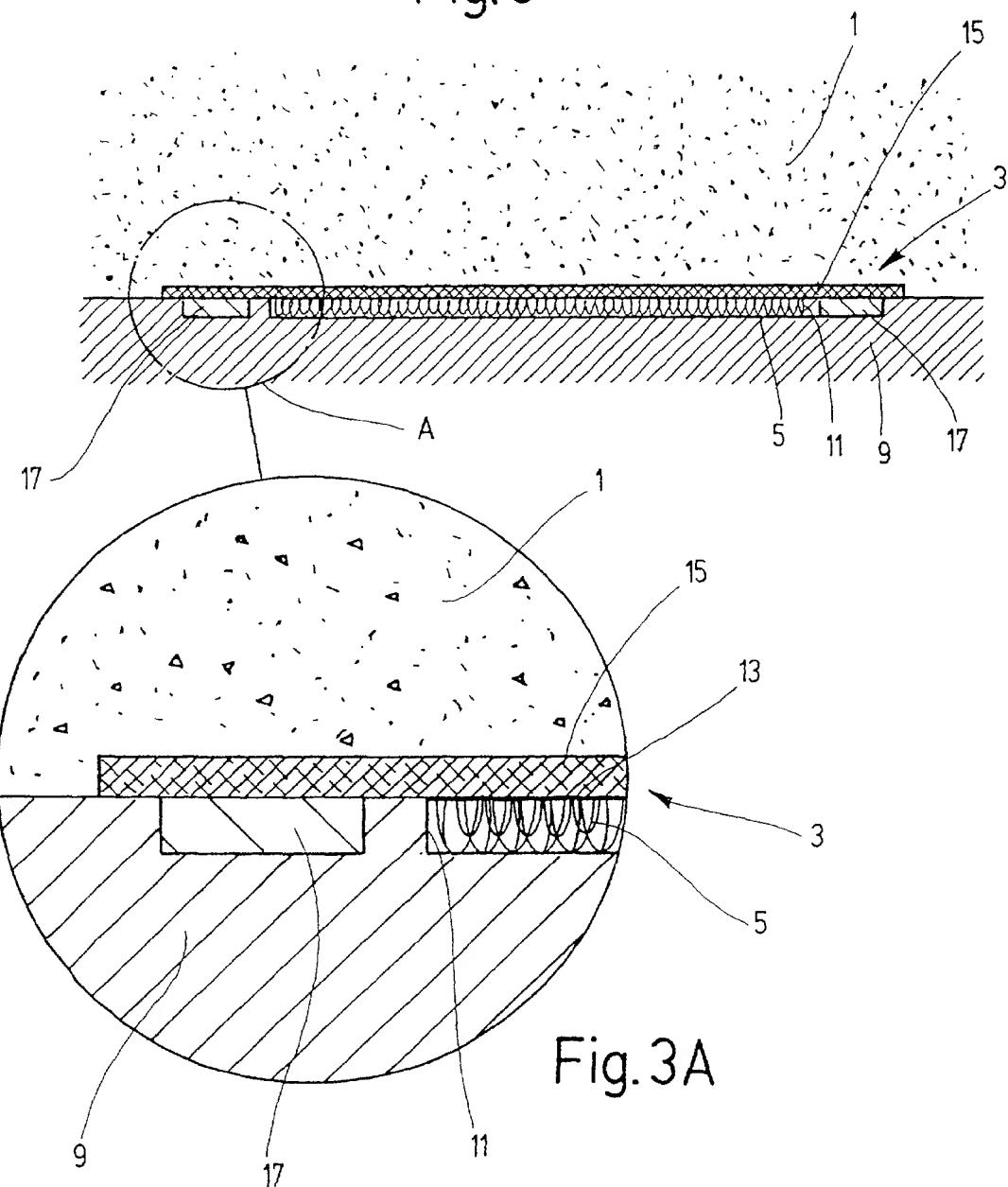


Fig. 3



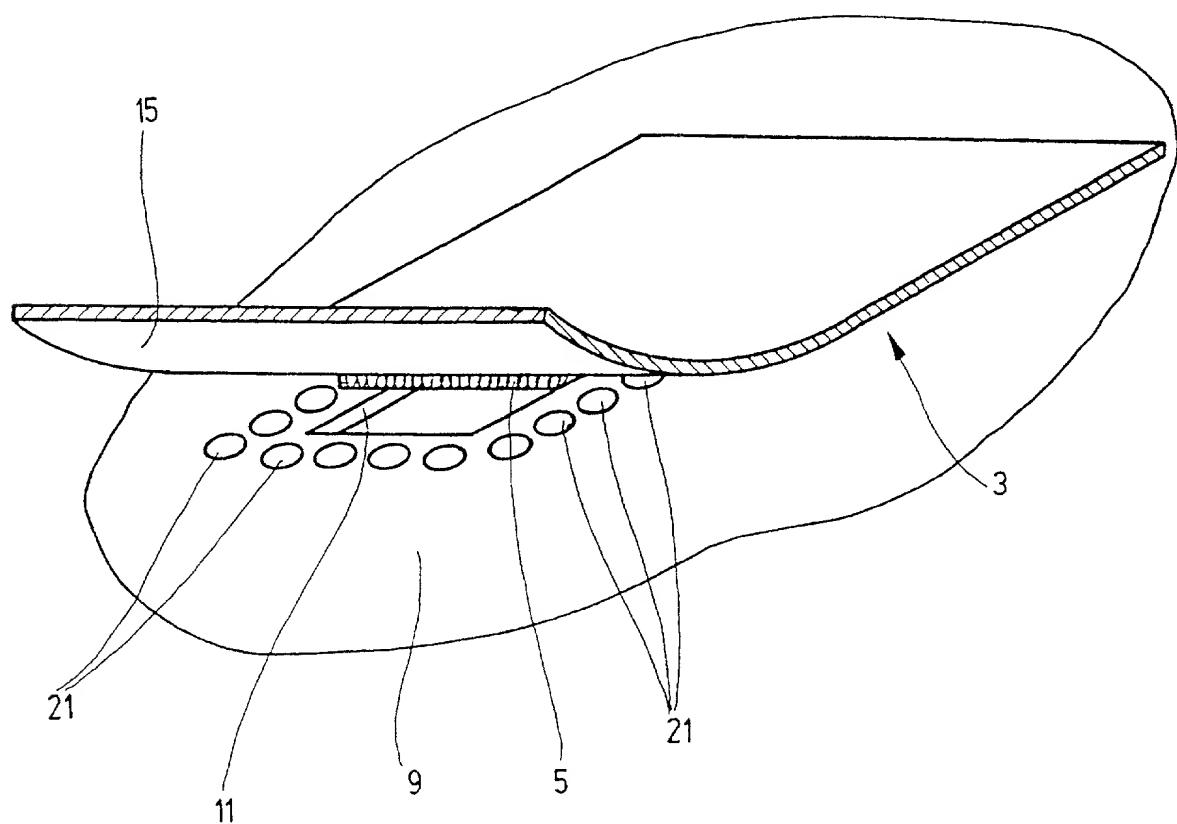
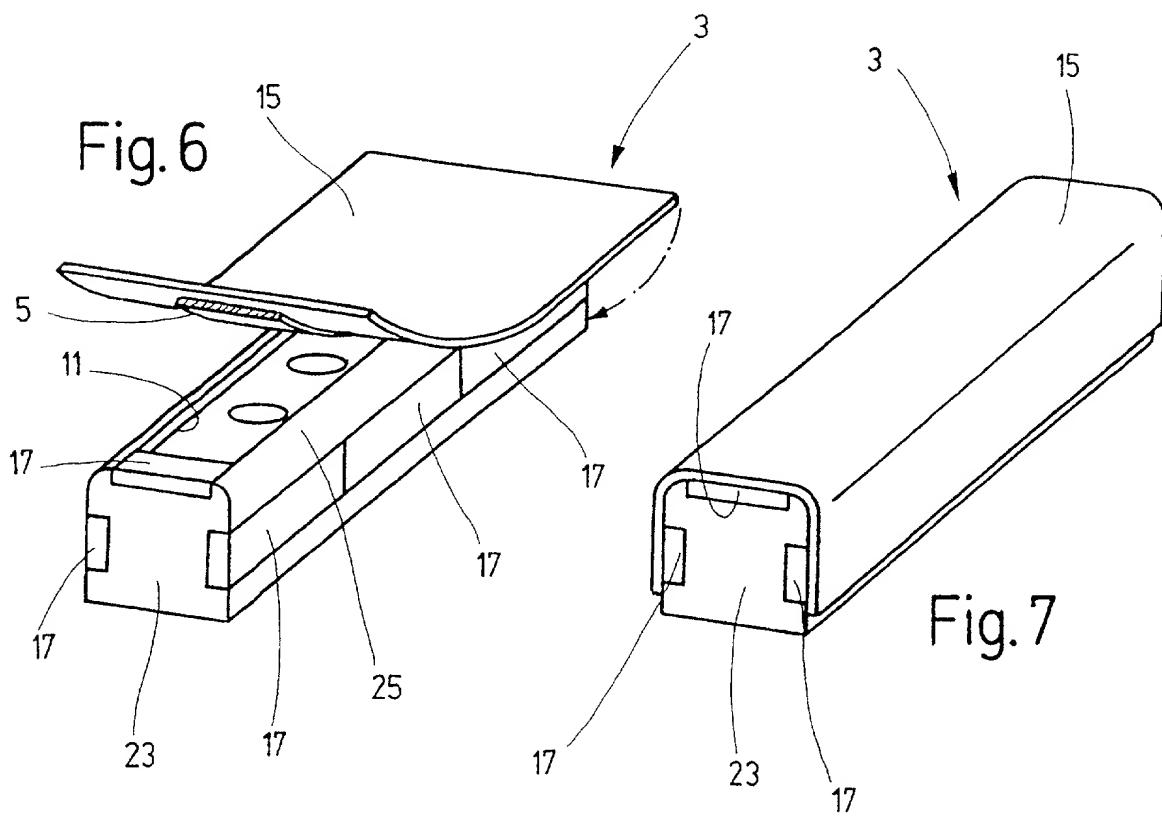
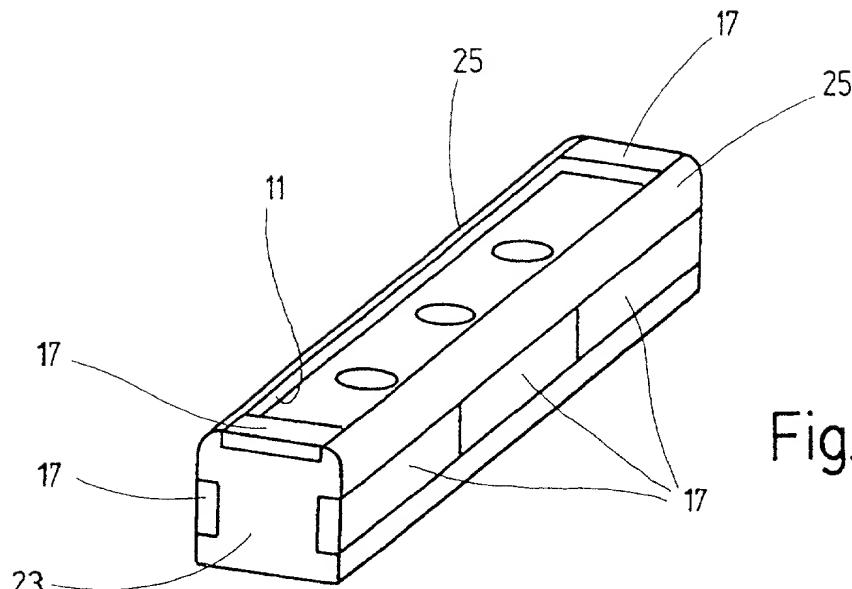


Fig. 4



# Declaration and Power of Attorney for Patent Application

## Erklärung für Patentanmeldungen mit Vollmacht

### German Language Declaration

Als nachstehend benannter Erfinder erkläre ich hiermit an Eides Statt:

daß mein Wohnsitz, meine Postanschrift und meine Staatsangehörigkeit den im nachstehenden nach meinem Namen aufgeführten Angaben entsprechen, daß ich nach bestem Wissen der ursprüngliche, erste und alleinige Erfinder (falls nachstehend nur ein Name angegeben ist) oder ein ursprünglicher, erster und Miterfinder (falls nachstehend mehrere Namen aufgeführt sind) des Gegenstandes bin, für den dieser Antrag gestellt wird und für den ein Patent für die Erfindung mit folgendem Titel beantragt wird:

deren Beschreibung hier beigefügt ist, es sei denn (in diesem Falle Zutreffendes bitte ankreuzen), diese Erfindung

wurde angemeldet am \_\_\_\_\_ unter der US-Anmeldenummer oder unter der Internationalen Anmeldenummer im Rahmen des Vertrags über die Zusammenarbeit auf dem Gebiet des Patentwesens (PCT)  
 \_\_\_\_\_ und am \_\_\_\_\_ abgeändert (falls zutreffend).

Ich bestätige hiermit, daß ich den Inhalt der oben angegebenen Patentanmeldung, einschließlich der Ansprüche, die eventuell durch einen oben erwähnten Zusatzantrag abgeändert wurde, durchgesehen und verstanden habe.

Ich erkenne meine Pflicht zur Offenbarung jeglicher Informationen an, die zur Prüfung der Patentfähigkeit in Einklang mit Titel 37, Code of Federal Regulations, § 1.56 von Belang sind.

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

#### METHOD FOR PRODUCING A SHAPED

#### FOAM BODY, ESPECIALLY A FOAM

#### PADDING ELEMENT FOR A VEHICLE SEAT

the specification of which is attached hereto unless the following box is checked:

was filed on August 3, 1998  
 as United States Application Number or PCT International Application Number PCT/EP98/04832 and was amended on \_\_\_\_\_ (if applicable).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, § 1.56.

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Prior Foreign Applications  
(Frühere ausländische Anmeldungen)

PCT/EP98/04832	WO
(Number) (Nummer)	(Country) (Land)

(Number) (Nummer)	(Country) (Land)
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Ich beanspruche hiermit Prioritätsvorteile unter Title 35, US-Code, § 119(e) aller US-Hilfsanmeldungen wie unten aufgezählt.

(Application No.) (Aktenzeichen)	(Filing Date) (Anmeldetag)
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(Application No.) (Aktenzeichen)	(Filing Date) (Anmeldetag)
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(Application No.) (Aktenzeichen)	(Filing Date) (Anmeldetag)
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(Application No.) (Aktenzeichen)	(Filing Date) (Anmeldetag)
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Priority Not Claimed  
Priorität nicht beansprucht

3 August 1998

(Day/Month/Year Filed) (Tag/Monat/Jahr der Anmeldung)
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(Day/Month/Year Filed) (Tag/Monat/Jahr der Anmeldung)
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(Status) (patented, pending, abandoned) (Status) (patentiert, schwebend, aufgegeben)
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(Status) (patented, pending, abandoned) (Status) (patentiert, schwebend, aufgegeben)
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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

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POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. (list name and registration number)

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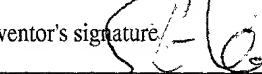
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Vor- und Zuname des einzigen oder ersten Erfinders	Full name of sole or first inventor <u>Konstantinos Poulakis</u>	
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(Supply similar information and signature for third and subsequent joint inventors.)